

March-22-12 10:35:23 AM

Page 1

Accept

Setup Start *NS1*

Stop *NS2*

40

Cust Item ID:

40

Customer:

Reference:

Date: 12/03/22 Tooling:

Date:

Run Start *NR1*

Date:

SPC (Y/N):

Date:

Stop *NR2*

100		0.00		
100	BAND SAW			
Bandsaw				
Jeaspa Bandsaw	Memo	0.00		
	Cut blank: 2.750" long			
110		0.00		
110	HAAS CNC VERTICAL MACHINING #1			
HAAS 1				
HAAS CNC vertical machine #1	Memo	0.00		
	1-Machine as per Folio FA555 and Dwg D3404Dwg Rev: <u>C</u> Folio Rev:			
	<u>AA</u> 2-Deburr			
120		0.00		
120	QC2- Inspect parts off machine FAI/FAIB			
QC				
Quality Control	Memo	0.00		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 82051

82051

Page 2

March-22-12 10:35:23 AM

Item ID: D3404-1

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: GHW Lug

Start Date: 22/03/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 29/03/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 QC8- Inspect parts - second check

0.00

130

QC

Memo

0.00

Quality Control

140

Identify as per dwg & Stock Location: W/4

0.00

140

Packaging

Memo

0.00

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

ME
12-04-09

W/O:		WORK ORDER CHANGES					
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Picklist Print

March-22-12 10:35:27 AM

Page 1

Work Order ID: 82051

82051

Parent Item: D3404-1

D3404-1

Parent Item Name: GHW Lug

Start Date: 22/03/2012

Required Date: 29/03/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP Rev:A05.09.01New issueKJ/JLM

IPP rev B 09.01.28 new geometry rev.C

EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.750X2.500

Purchased

No

100

f

26.3500

0.2291

9.646316

M304B0 750X2 500

**

9.667'

SL 12/04/04

304 BAR .750 X 2.50

Location

Loc Qty

Loc Code

MAT050

26.35

120674

26.35

9.667'

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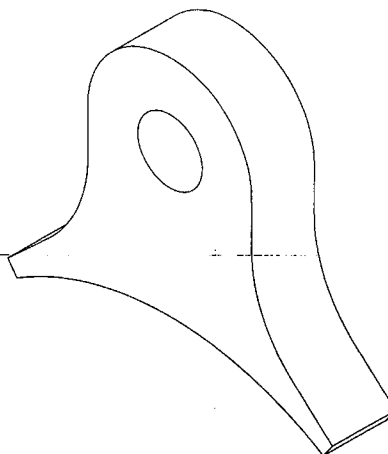
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 82051ML5

12/03/22



D3404-1 GHW LUG

RELEASED
 06/12/18/NW

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL BAR
 PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
 REF. DART SPEC. M304B
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.030 TO 0.060 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.34 lbs

C	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. B6-2, 2.30 RAD WAS 2.13. C7-2 1.14 DIM. WAS 1.20.	AJS	08.12.02
B	UPDATE M-SPEC	PH	05.06.14
A	NEW ISSUE	PH	05.03.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
DATE	08.12.02	COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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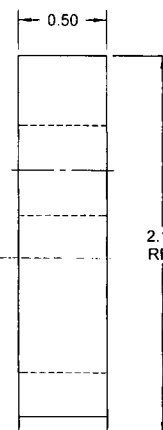
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NOTE: Date & initial all entries

Technical drawing of a mechanical part, likely a bracket or support, showing dimensions and features:

- Overall width: 2.58
- Overall height: 1.14
- Top width (inner): 1.30
- Top radius: R0.65 REF
- Central hole diameter: $\varnothing 0.510$
- Side radius: R1.00
- Bottom width (inner): 2.44
- Bottom radius: R2.30
- Bottom fillet radius: 0.125
- Feature C: A chamfer or fillet at the bottom corners, indicated by a triangle with the letter C.
- Feature G: A centerline or axis of symmetry, indicated by a vertical line with the letter G and the text "SYM ABOUT".



RELEASE
08/12/18

DESIGN	PH	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3404	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		GHW LUG	NTS
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